

General Information				
Product Description				
GF-reinforced; Warpage, Low; Rigidity, High				
General				
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight			
Features	• High Rigidity		• Low Warpage	
Uses	• Automotive Applications • Automotive Electronics		• Electrical/Electronic Applications • General Purpose	
ASTM & ISO Properties ¹				
Physical	Dry	Conditioned	Unit	Test Method
Density	1.66	--	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	18	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	12	--	cm³/10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.59	--	%	
Flow : 130°C, 2.00 mm	0.32	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.14	--	%	
Equilibrium, 23°C, 50% RH	1.3	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	17600	11500	MPa	ISO 527-1/1
Tensile Stress (Break)	139	86.0	MPa	ISO 527-2/5
Tensile Strain (Break)	1.1	1.3	%	ISO 527-2/5
Flexural Modulus ³	16000	10900	MPa	ISO 178
Flexural Stress ³	236	151	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	4.1	5.1	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179
23°C	27	35	kJ/m²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	234	231	°C	ISO 75-2/B
1.8 MPa, Unannealed	214	196	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	1.0E-5	--	cm/cm/°C	
Transverse	4.0E-5	--	cm/cm/°C	

Reny™ 2620

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	HB	--		UL 94

Additional Information

Conditioned Conditioned to 50% RH

Processing Information

Injection	Dry	Unit
Drying Temperature		
Hot Air Dryer, A	120	°C
Hot Air Dryer, B	80	°C
Drying Time		
Hot Air Dryer, A	> 3.0	hr
Hot Air Dryer, B	> 12	hr
Rear Temperature	265	°C
Middle Temperature	270	°C
Front Temperature	275	°C
Nozzle Temperature	275	°C
Mold Temperature	120 to 140	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate-Fast	
Screw Speed	60 to 150	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 100-mm square

³ 2.0 mm/min

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